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D3319-1**Job Sheet 206772****Part No:** D3319-1**Job Qty:** 12 pcs**Part Name:** Forward Wearplate**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 2/10/20**Job Tracking No:****Due Date:** 3/2/20**Created By:** Marie Lajeunesse**Type:** Stock**Description:** SIOP

Note: IPP: B 05.10.14 Added step 9, dwg rev B KJ/EC IPP Rev:C Now on Waterjet 06-10-26 JLM IPP REV:D
17.10.25 AS PER DWG REV.D DD VERF:JFS

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	12 pcs		3/2/20	0.17	1.25	Waterjet - Flow		α 20/04/13
							Waterjet - Omax		
110	QC 2	12 pcs		3/2/20	0.00	0.00	QC 2 - 1		α 20/04/13
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		

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120	QC 8	12 pcs	3/2/20	0.00 0.00	QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 2 - 76	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
140	Small Fab - Brake NC - B4B	12 pcs	3/2/20	0.25 0.87	Small Fab - Brake - 1 - B4B	
					Small Fab - Brake - 2 - B4B	
					Small Fab - Brake - 3 - B4B	
160	Automated Welding - B4B	12 pcs	3/2/20	0.00 3.08	Automated Welding - 1 - B4B	
170	QC 10	12 pcs	3/2/20	0.00 0.00	QC 10 - 10	
					QC 10 - 18	
					QC 10 - 24	
					QC 10 - 43	
					QC 10 - 50	
					QC 10 - 58	
					QC 10 - 9	
					QC 10 - 68	
180	QC 5	12 pcs	3/2/20	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	

DAS 82
40 9-89

APR 14 2020

APR 17 2020

MF

cl

					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	a
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
190	Spray Paint - 2 - B4B	12 pcs	3/2/20	0.00 2.00	Spray Paint - 1 - B4B	DAS 141 APR 20 2020
					Spray Paint - 2 - B4B	9-89
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
200	QC 3	12 pcs	3/2/20	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	DAS 81 9-89
					QC 3 - 61	APR 21 2020
					QC 3 - 81	
					QC 3 - 82	
210	Packaging 3-1 - Stock - B4B	12 ✓ pcs	3/2/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B ✓	DAS ST446 80 APR 22 2020
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	

				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
220 QC 21 - SA	12 ✓ pcs	3/2/20	0.00 0.00	QC 21 - SA - 21 ✓	ST446
				QC 21 - SA - 70	
				QC 21 - SA - 53	DAS

Part Op 100 - 1-Cut as per Dwg D3319 Dwg Rev: D Prog Rev: D 2-Deburr if necessary 21 APR 22 2020
 Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)
 120 - QC8- Inspect parts - second check)
 140 - (Form as per dwg) 1- Form using DT8326 & DT8261 as per Dwg D3319Rev: 21 2- Form flat on press using DT8776 block
 160 - 8259 HARDCOAT B: M/39068
 170 - (QC10- Inspect visual per QSI004- ground welds)
 180 - (QC5- Inspect part completeness to step on W/O)
 190 - Spray Paint / NDT Room) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURE COATING AS PER DWG NOTE 9 SHEET ONE. BATCH: S270770
 200 - (QC3- Inspect Part Finish)
 210 - (Identify as per dwg & Stock Location:) Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd. P/N: D3319-1, B/N: BXXXXX For Product Eligibility see PDA05-18 and Stock Location:
 220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	7.5360 sf (.628 ea)	100-Waterjet - Flow - 1	3 S243464 = 2-512

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S18GA	8	320	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearplate	4.980inches ± 0.030	5.010 4.950		
2	Wearplate	1.600inches ± 0.010	1.610 1.590		
3	Wearplate	2.660inches ± 0.010	2.670 2.650		
4	Wearplate	3.190inches ± 0.010	3.200 3.180		
5	Wearplate	3.563inches ± 0.010	3.573 3.553		
6	Wearplate	4.710inches ± 0.030	4.740 4.680		
7	Wearplate	0.600inches ± 0.030	0.630 0.570		
8	Wearplate	10.576inches ± 0.010	10.586 10.566		
9	Wearplate	11.942inches ± 0.010	11.952 11.932		
10	Wearplate	18.090inches ± 0.030	18.120 18.060		
11	Wearplate	0.316inches + 0.006 - 0.001	0.322 0.315		
12	Wearplate	0.546inches ± 0.010	0.556 0.536		
13	Wearplate	0.316inches + 0.006 - 0.001	0.322 0.315		
14	Wearplate	0.670inches ± 0.010	0.680 0.660		
15	Wearplate	0.190inches + 0.005 - 0.001	0.195 0.189		
16	Wearplate	3.815inches ± 0.010	3.825 3.805		
17	Wearplate	16.100inches ± 0.010	16.110 16.090		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S270237



Part: D3319-1

Job No: 206772

Serial No/Batch: S270237

Revision: D

Inspector:

Exp Date:

Instructions: Various STC's

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